

June-24-14 2:00:02 PM

ASA F

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

5

Cust Item ID:

5

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-06-24 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run	Start	*NR1*
	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
-----------------	---------------------

D5093 A

100

0.00

100

FLOW WATER JET

0.00

Waterjet

FLOW CNC Waterjet

Memo

1-Cut D5093-1 as per Dwg

Dwg Rev: 1

Prog Rev: A

2-Deburr as required

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

0.00

OC

Quality Control

Memo

DAS
23
9.8

DAS
23
9-89

14-06-20

14-26 26

Work Order ID 121331

June-24-14 2:00:02 PM

121331

Page 2

Item ID: D5093-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door Bracket Assembly
 Start Date: 6/24/14 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 6/24/14 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00	<i>EB</i> 14/6/26 <i>8/14/6/26</i>			<u>(5)</u>			
120 QC Quality Control	Memo	0.00							
140	NC BRAKE	0.00				<u>5</u>			<i>14/06/27</i>
140 Brake NC Brake NC	Memo Bend as per Dwg	0.00			DAS 30 9-89				
150	QC5- Inspect part completeness to step on W/O	0.00	<i>AS</i> 17 189 14/6/26			<u>5</u>			
150 QC Quality Control	Memo	0.00							

Work Order ID 121331

June-24-14 2:00:02 PM

121331

Page 3

Item ID: D5093-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Door Bracket Assembly

Start Date: 6/24/14 Start Qty: 5.00

5

Cust Item ID:

Required Date: 6/24/14 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

160

Small Fab

Memo

0.00

0.00

Small Fab

ASSEMBLE AS PER DWG

DAS

27
9-89

170

170

QC

Memo

QC5- Inspect part completeness to step on W/O

0.00

0.00

Quality Control

180

180

Packaging

Memo

Identify as per dwg & Stock Location: STB2

0.00

0.00

Packaging

DAS

28
9-89

JUN 26 2014

Work Order ID 121331

121331

Page 4

June-24-14 2:00:02 PM

Item ID: D5093-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Door Bracket Assembly
Start Date: 6/24/14 Start Qty: 5.00 *5* Cust Item ID:
Required Date: 6/24/14 Req'd Qty: 5.00 *5* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ 14-06-27
MF
14-06-26

Picklist Print

June-24-14 2:00:05 PM

Page 1

Work Order ID: 121331

121331

Parent Item: D5093-041

D5093-041

Parent Item Name: Door Bracket Assembly

Start Date: 6/24/14

Required Date: 6/24/14

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 14.04.14 NEW ISSUE DD VERF:JLM
REV:B 14.06.23 as per dwg rev.A DD VERF:JLM

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased		No			sf	721.3700		①			DAS 23 9-89
M304S18GA													14-06-26
304/316 .050 Sheet													

Location	Loc Qty	Loc Code
MAT019	709.37	
117188	3	
117766	5	
120604	5	
122325	3	
123155	3	
124572	38	
M126647	31.55	
M128254	91.57	
M128435	123.25	
M128864	126	
M129530	280	
MAT020	12	
124029	2	
M126098	10	

D3622-1

Manufactured No

Each 54.0000

5

D3622-1

Ball Stud

**

FF 14-06-26

Location	Loc Qty	Loc Code
ST052	54	
114881	34	
119636	20	

Picklist Print

June-24-14 2:00:05 PM

Page 2

Work Order ID: 121331

121331

Parent Item: D5093-041

D5093-041

Parent Item Name: Door Bracket Assembly

Start Date: 6/24/14

Required Date: 6/24/14

Start Qty: 5.00

Required Qty: 5.00

MS21043-5

Purchased

No

Each

183.0000

5

MS21043-5

FF 14-06-26

Nut

Location

Loc Qty

Loc Code

FG

20

101418

20

ST306

163

116548

88

121584

11

m129499

64

Each

212.0000

10

NAS1149C0563R

Purchased

No

NAS1149C0563R

FF 14-06-26

Washer

Location

Loc Qty

Loc Code

ST278

212

m125928

212

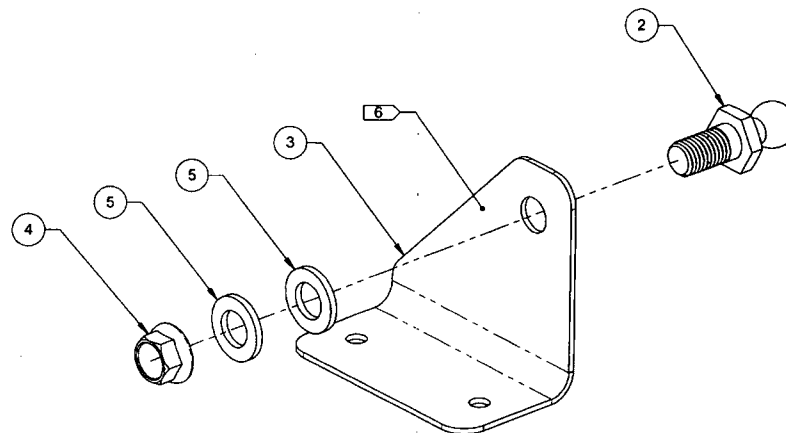
10

June-24-14 2:00:05 PM

Shop Packet Print

Page 2

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D5093-041	DOOR BRACKET ASSEMBLY
2	1	D3622-1	BALL STUD
3	1	D5093-1	BRACKET
4	1	MS21043-5	NUT
5	2	NAS1149C0563R	WASHER



121331 ML5 14-06-24
 NO
 WORK ORDER
 WITHOUT NOTICE
 SUBJECT TO AMENDMENT
 UNCONTROLLED COPY
 ENGINEERING
 RETURN TO
 SHOP COPY

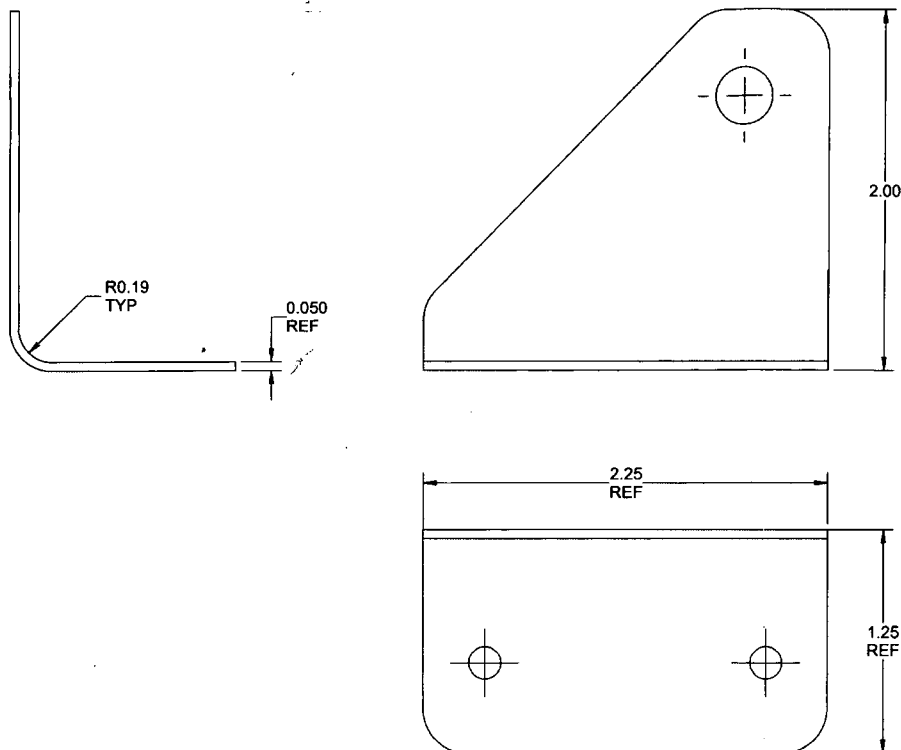
D5093-041 DOOR BRACKET ASSEMBLY

RELEASED
 2014-06-20

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.12 lbs

APPROVED	A	NEW ISSUE		AK	14.04.04
	REV.	DESCRIPTION		BY	DATE
	DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
	DRAWN	HS			
	CHECKED	RF	DRAWING NO. REV. A		
	MFG. APPR.	DD	D5093 SHEET 1 OF 3		
APPROVED		HS	TITLE SCALE		
DE APPR.		DS-#	DOOR BRACKET NTS		
DATE		14.04.04		COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

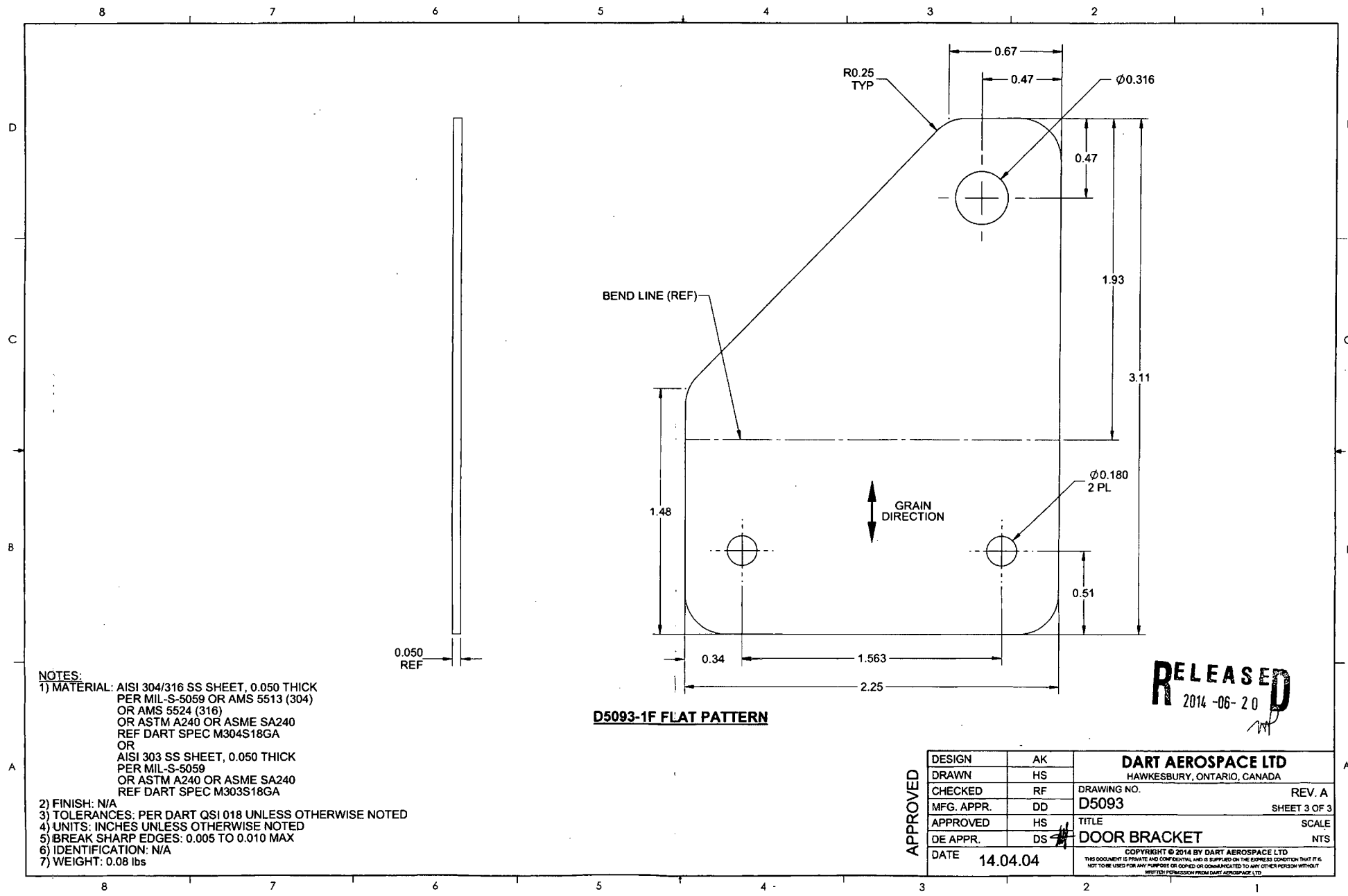


D5093-1 BRACKET

- NOTES:**
- 1) MATERIAL: MADE FROM D5093-1F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.08 lbs

APPROVED	DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	HS		
	CHECKED	RF	DRAWING NO.	REV. A
	MFG. APPR.	DD	D5093	SHEET 2 OF 3
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	DOOR BRACKET	NTS
DATE		14.04.04	<small>COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
2014-06-20
WJ



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.050 THICK
PER MIL-S-5059 OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA
OR
AISI 303 SS SHEET, 0.050 THICK
PER MIL-S-5059
OR ASTM A240 OR ASME SA240
REF DART SPEC M303S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

D5093-1F FLAT PATTERN

RELEASED
2014-06-20

APPROVED	DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	HS		
	CHECKED	RF	DRAWING NO. D5093	REV. A
	MFG. APPR.	DD	SHEET 3 OF 3	
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	DOOR BRACKET	NTS
	DATE	14.04.04	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	